

**Work Order ID 52263**

September 22, 2009 8:06:53 AM



Page 1

Item ID: D3048-1

Revision ID: A2

Item Name: Doubler

Start Date: 9/22/09 Start Qty: 8.00

Accept



Setup Start



Required Date: 9/25/09 Req'd Qty: 8.00



Cust Item ID:



Customer:

Reference:

Approvals: Process Plan: *W*  
QC:Date:  
Date:Tooling:  
SPC (Y/N):Date:  
Date:Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr Revision Nbr

D3048 Rev A2

100  
  
FLOW WATER JET

0.00

*HB 9-9-22*Waterjet  
  
Memo

0.00

FLOW CNC Waterjet  
1-Cut as per Dwg D3048 Dwg Rev: A2 Prog Rev: A2 2-  
Deburr if necessary*(8)*110  
  
QC2- Inspect parts off machine FAI/FAIB

0.00

*HB 9-9-22*QC  
  
Memo

0.00

120  
  
QC8- Inspect parts - second check

0.00

QC  
  
Memo

0.00

*2010/22**(8) /*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Accept



Setup Start



Required Date: 9/25/09 Req'd Qty: 8.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Brake NC

NC BRAKE

0.00

80 09/09/23

8 5

Brake NC

Memo

Form on CNC Brake per Dwg D3048

140



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

80 09/09/23

8 Ø

Hand Finishing

Memo

0.00

150



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

80 09-9-23

8 Ø

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 52263**

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Page 3

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Accept



Setup Start



Required Date: 9/25/09 Req'd Qty: 8.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date: Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

160



Packaging

Packaging

Operation  
DescriptionIdentify as per dwg & Stock Location: CHSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

0.00

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

9/21/23 8x sp

09/09/24 TD  
WF 09-09-24

# Picklist Print

September 22, 2009 8:06:52 AM

Page 1

Work Order ID: 52263



Parent Item: D3048-1RevA2



Parent Item Name: Doubler

Start Date: 9/22/09

Required Date: 9/25/09

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased		No		100	sf	93.0033	29.1225	30.000		

2024-T3 .063 sheet



## Warehouse

### Location

#### Main Warehouse

MAT	93.00332419	
102942	1.5	
105916	3.69	
106223	1.47	
109463	0.00947368	
110980	5.4854	
111787	78.8484505	
19059	2	

## Loc Qty

## Loc Code

1B 9-4-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	52263
Description: Doubler	Part Number:	D3048-1
Inspection Dwg: D3048	Rev: A2	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by: <u>LB</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: 9-9-22	Date: 09/09/22	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.11.27	New Issue	KJ/EC	

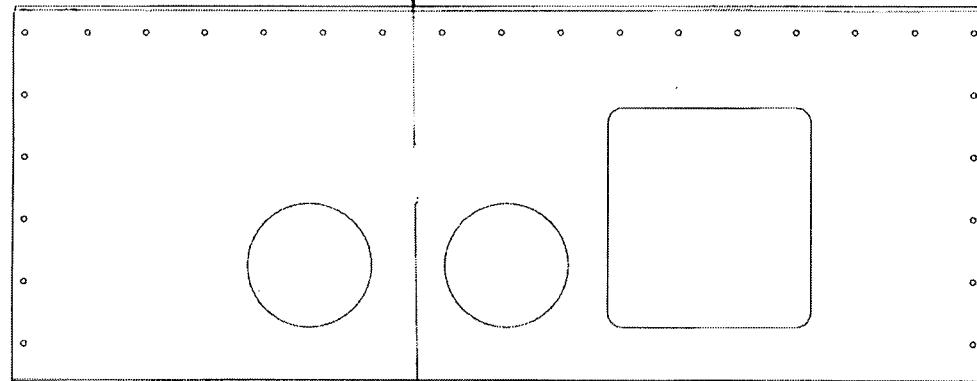
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

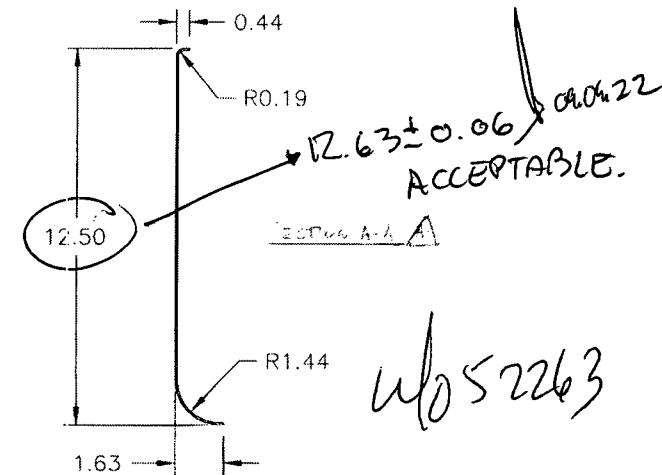
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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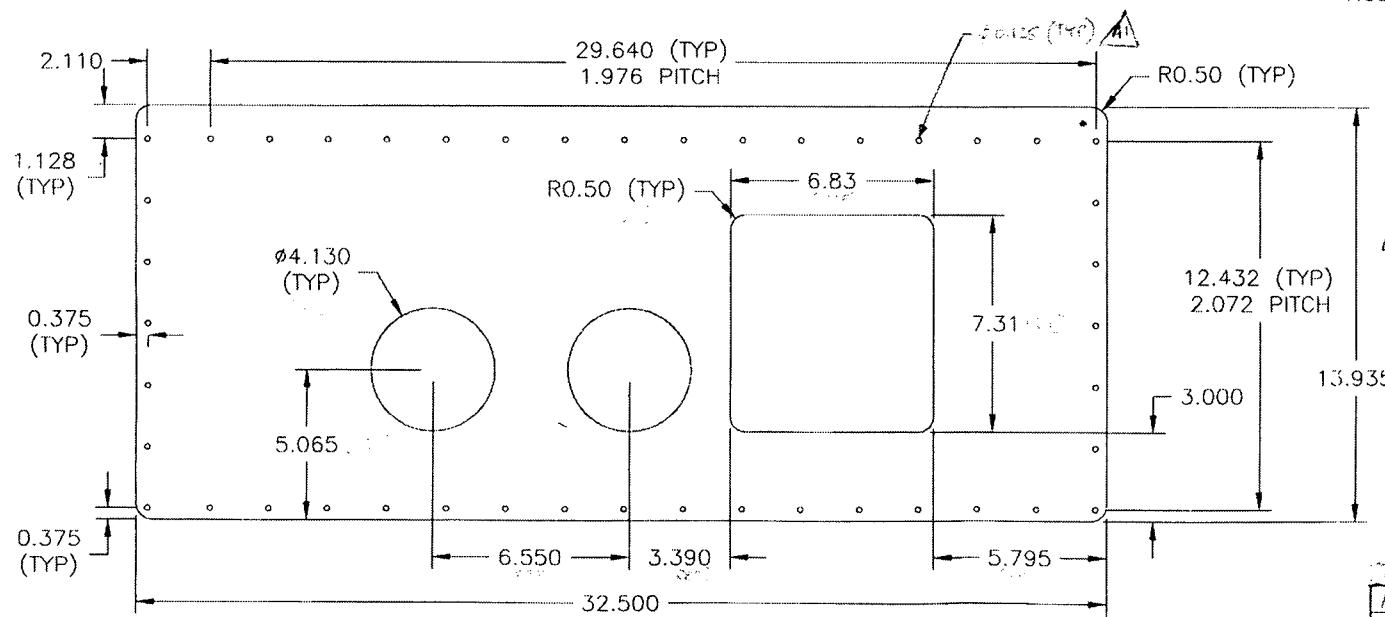
• NOTE: Date & initial all entries



D3048-1



12.63 ± 0.06  
ACCEPTABLE.  
W052263



D3048-1 FLAT PATTERN

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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. MARKSBURY, ONTARIO, CANADA
RF			
CHECKED	APPROVED		DRAWING NO.
			D3048
DATE		REV. A	SHEET 1 OF 1
01.09.25		SCALE	1:14
		TITLE	DOUBLER

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